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RBE332A94-3400-03-19**Job Sheet 191115****Part No:** RBE332A94-3400-03-19**Job Qty:** 2 pcs**Part Name:** Target Block 1 Fabrication**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:****Bill of Materials**

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Container No: S170143**Part:** RBE332A94-3400-03-19**Job No:** 191115**Serial No/Batch:** S170143**Revision:** A**Inspector:****Exp Date:****Instructions:****Date:** 04/06/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/22/19		0.00	0.40	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/22/19		0.00	0.00	QC 5 - 10		DAS 19 9-09
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 21 9-09 APR 08 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	2 pcs	3/22/19		0.00	0.00	QC 21 - SA - 21		DAS 21 9-09 APR 08 2019
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 8.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90591A171	Hex Nut	6 Ea (3 ea)	100-Small Fab - 1	5438414-8
91280A636	Hex Head Cap Screw	6 Ea (3 ea)	100-Small Fab - 1	5157274
98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	6 (3 ea)	100-Small Fab - 1	5144291
RBE332A94-3400-03-20 Base		2 pcs (1 ea)	100-Small Fab - 1	5165283

Job Allocations

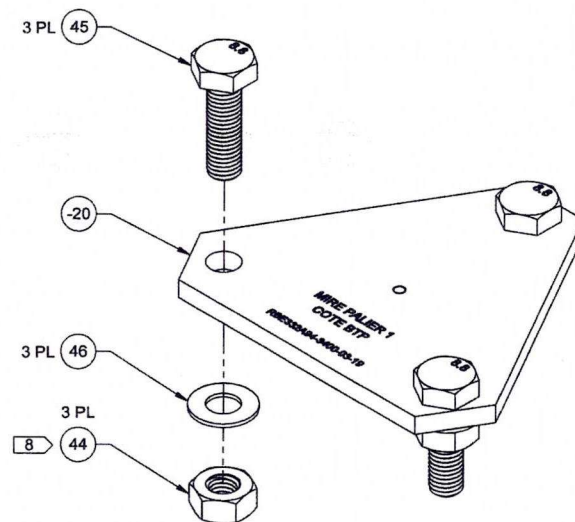
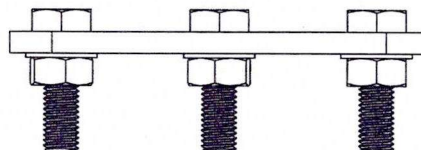
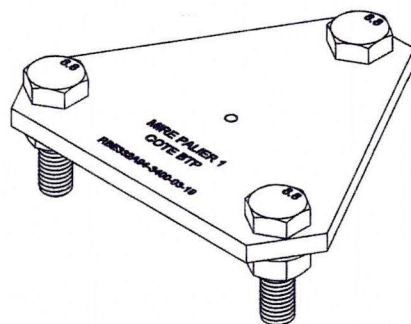
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	6	100	0
	91280A636	6	23	0
	98023A031	6	0	0
	RBE332A94-3400-03-20	2	0	0

Part Specifications

Specifications could not be found.

Plex 2/21/19 1:06 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-20	1	RBE332A94-3400-03-20	BASE
44	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
45	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
46	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.



RBE332A94-3400-03-19 TARGET BLOCK 1 FABRICATION

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191115 MLC5
14-02-21

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 44 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 20 OF 26
APPROVED	WJP	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					